

Date: Wednesday, 7/5/2006 2:50:05 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 350/212/130 BASKET LID							
Job Number	: 27816B										
Estimate Number	: 10193										
P.O. Number	: N/A		Part Number	: D2512							
This Issue	: 7/5/2006 S.O. No. : N/A		Drawing Number	: D2512 REV D2							
Prsht Rev.	: NC		Project Number	: N/A							
First Issue	: N/A		Drawing Revision	: D2							
Previous Run	: 27815B		Material	: N/A							
Written By	<u>See J.A comment below</u>		Due Date	: 7/30/2006							
Checked & Approved By	<u>J.A 06.07.05</u>		Qty:	1 Um: Each							
Comment	: Rev Est:M 03.01.31 Added D2012-117 for D130-701-041 KJ/ RF Est Rev:N 06.04.05 Added level21		EC								
Additional Product											
Job Number:											
Seq. #:	Machine Or Operation:	Description :									
1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W									
Comment: Qty.: 45.7594 f(s)/Unit Total : 45.7594 f(s)											
Pick: 3/4"x3/4" 304/316 SS tube .063" wall Batch: <u>M101309</u> → 518,53											
2.0	D31663	Basket Hoop									
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)											
Pick: Qty Part Number Description Batch 1 D3166-3 Basket Hoop <u>B27327</u> <u>Cpl 06.07.18</u>											
3.0	D2506	Placard									
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)											
Pick: Qty Part Number Description Batch 1 D2506 Label Plate <u>326631-2</u> <u>Cpl 06.07.18</u>											
4.0	D23271	Spacer Bushing									
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)											
Pick: Qty Part Number Description Batch 2 D2327-1 Bushing <u>B26742</u> <u>Cpl 06.07.18</u>											

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

Date: Wednesday, 7/5/2006 2:50:05 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 27816B

Part Number: D2512

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D22321 Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
2 D2232-1	Hinge plate	325238
-		

CPL 06-07-18

6.0 D2581 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
2 D2581	Mounting Bracket	327524

CPL 06-07-18

7.0 M304EX07516F Expanded Metal Flat Stai



Comment: Qty.: 18.0000 sf(s)/Unit Total : 18.0000 sf(s)

Pick:

Qty Part Number	Description	Batch
18 sf	M304EX0.75-16F Expanded Metal	M101341

CPL 06-07-25

8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

2-Cut (4) D2236 From D3166-3

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

CPL 06-07-25

5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required

9.0 QC9/6 DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

10 06/07/27 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

 NoDQA: 

Date: 06/08/03

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Wednesday, 7/5/2006 2:50:05 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 27816B

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

SC
pr

06/07/27

(1)

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

Batch: M101667

FC 06 07 27D

12.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

13.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

14.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Doc 08/03 (1)

Job Completion



C 2008102

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____



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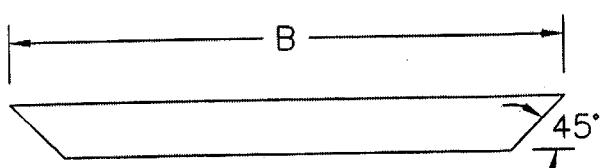
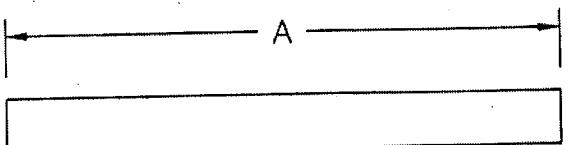
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CHECKED <i>CH</i>	APPROVED <i>CH</i>	DRAWING NO. D2512	REV. D SHEET 1 OF 4
DATE 01.04.19	TITLE BASKET LID ASSEMBLY (350/212)		SCALE NTS

RELEASED
01.04.27 *CH*

A	95.11.21	NEW ISSUE
B	96.05.24	ADDED LATCH CHANNEL & LABEL PLATE
C	99.07.06	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP. DEO 9074
D	01.04.19	CHANGE HINGE
D1	CH CP 03.01.20	ADD D2012-117 FOR D130-701-041
D2	CH CP 04.09.20	TACK WELD ANTI-SKID AREA

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT



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WORK ORDER
NO. 27816-B

D2512-1/-3/-5/-7

CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

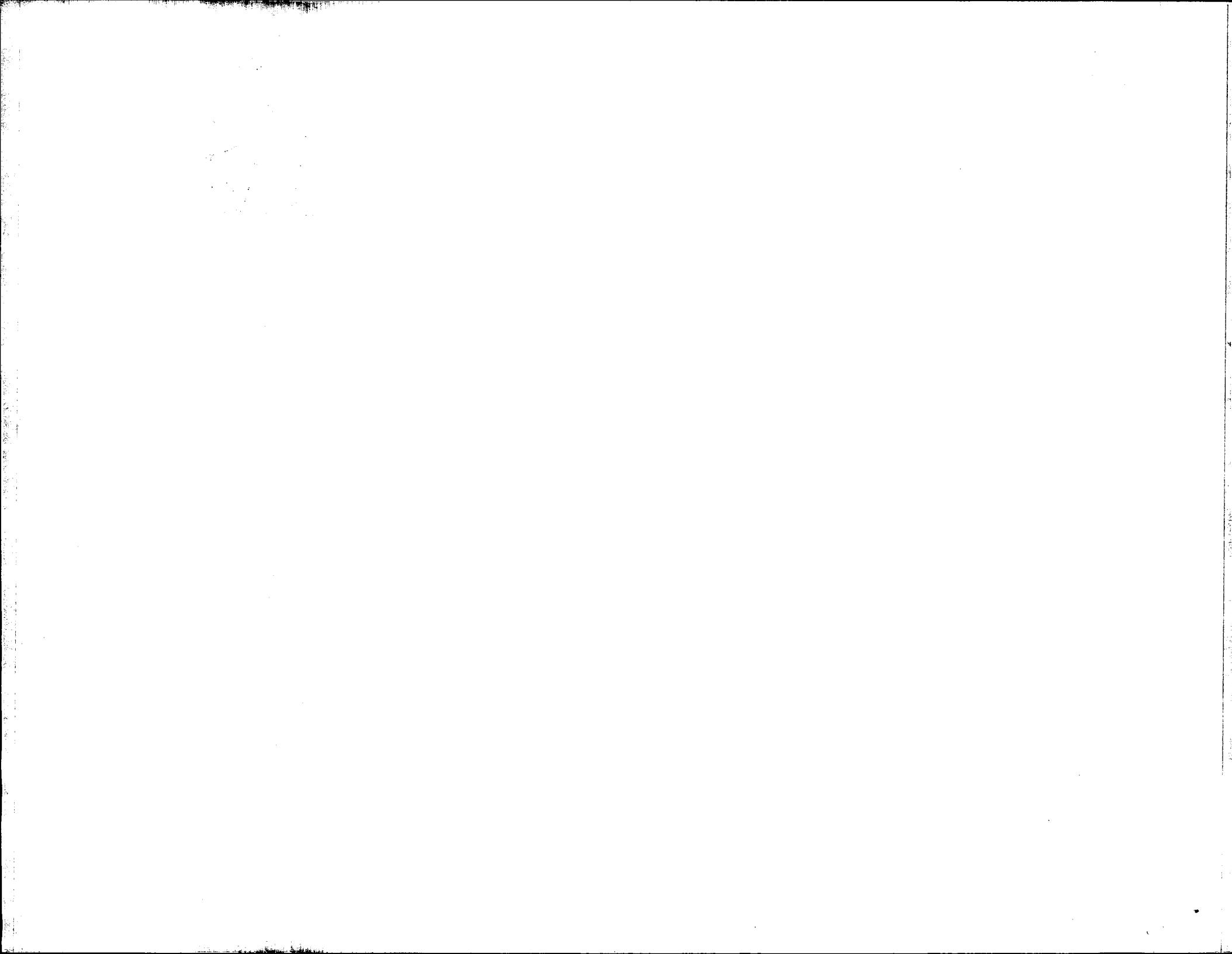
MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

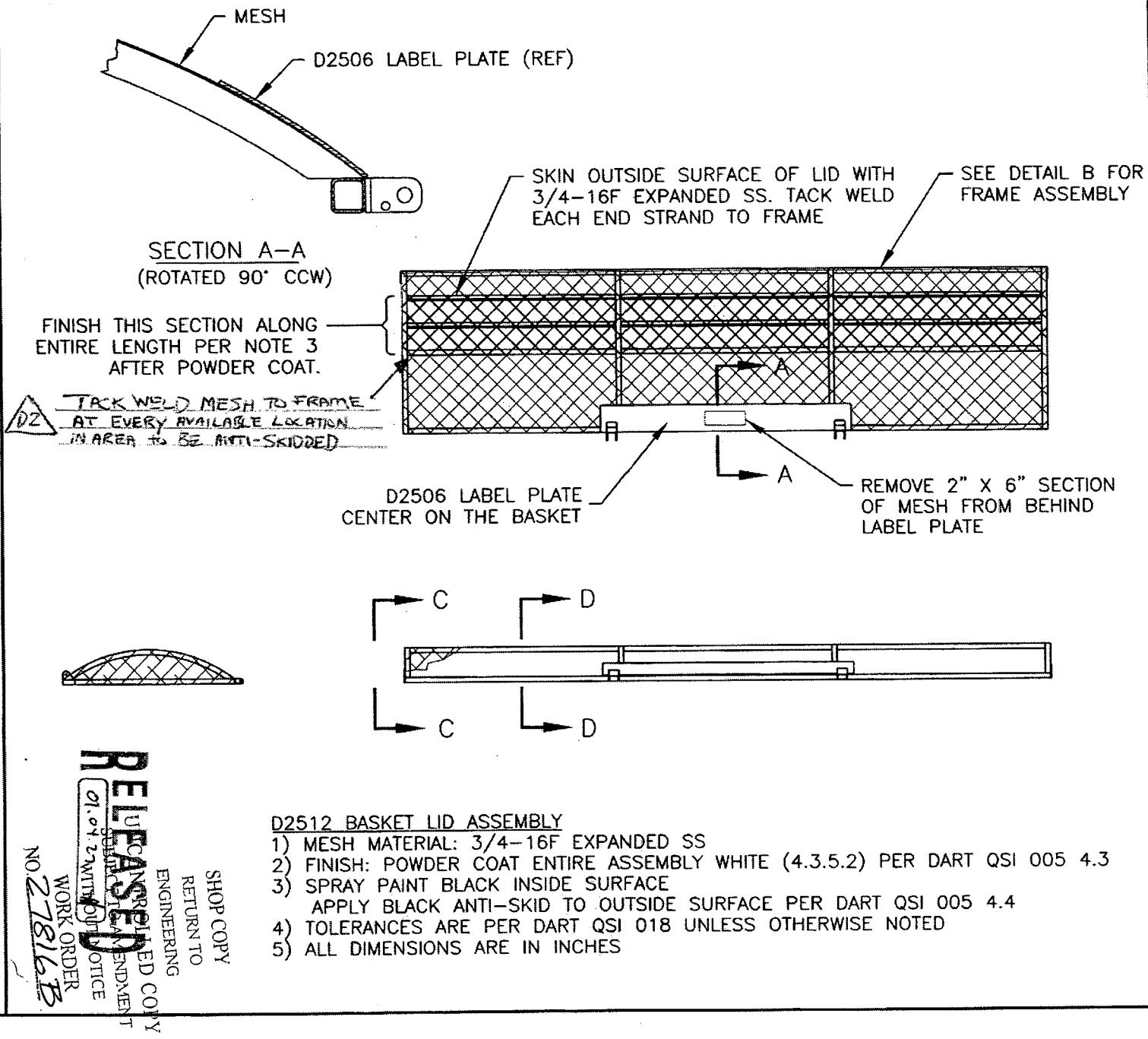
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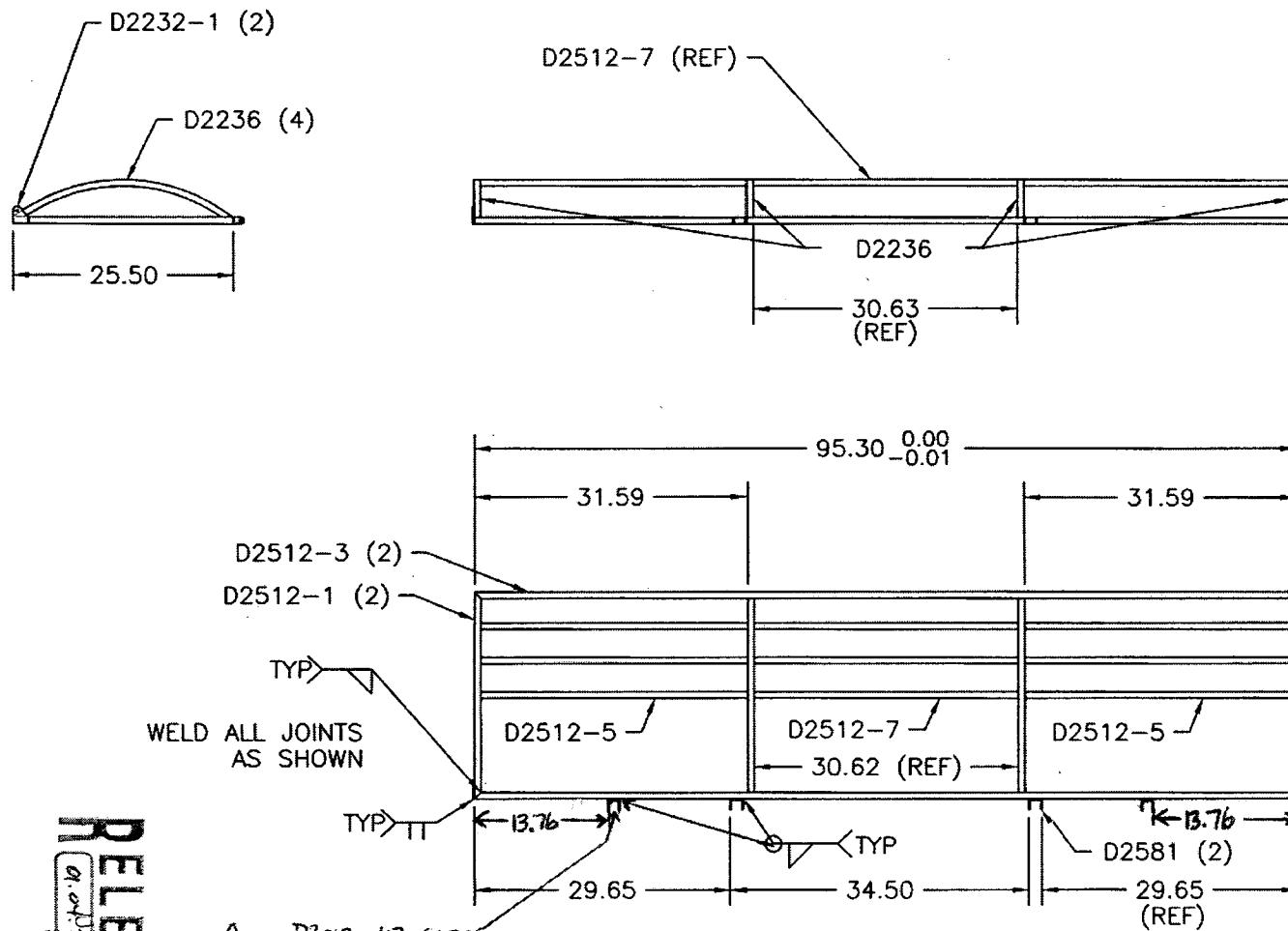
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DATE 01.04.19		SHEET 2 OF 4 TITLE BASKET LID ASSEMBLY (350/212) SCALE 1:20

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CHECKED	APPROVED	DRAWING NO.
DATE	01.04.19	TITLE

REV. D
SHEET 3 OF 4
SCALE 1:20



DETAIL B
FRAMEWORK SHOWN FOR CLARITY
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ALL DIMENSIONS ARE IN INCHES

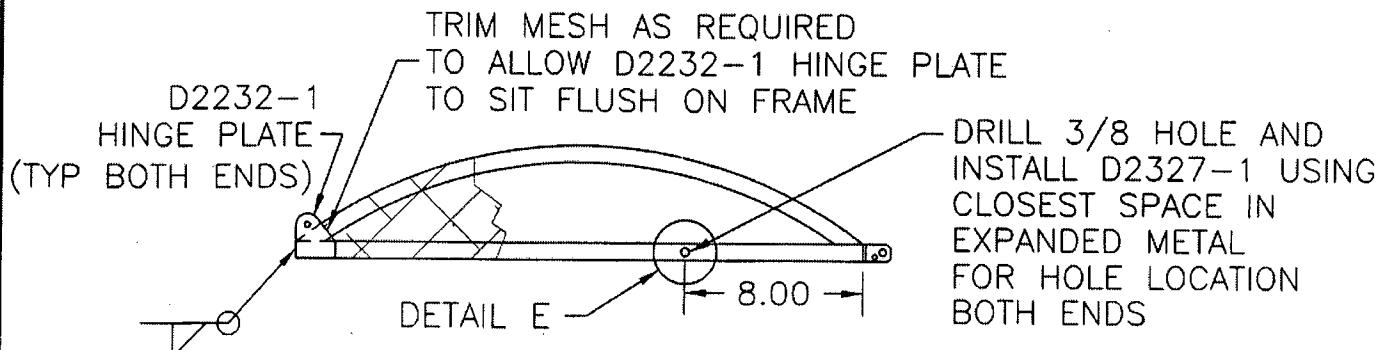
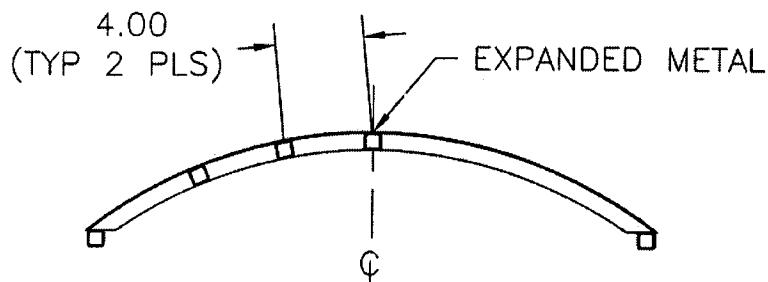
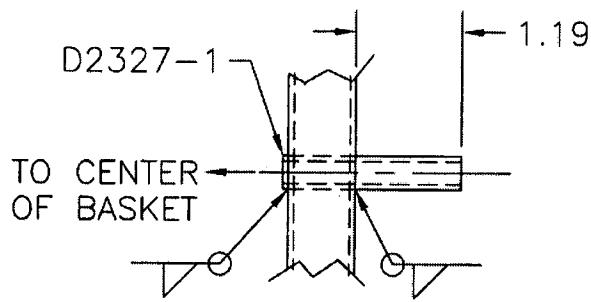
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DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)	SCALE 1:8

SECTION C-C SIMILAR BOTH END RIBSSECTION D-D SAME BOTH CENTER RIBS

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